

Loctite® EA 9459 is a self-leveling, roller-coatable, one-component epoxy adhesive.

#### Features

One Component – No Mixing Required  
Self-Leveling  
Excellent High Temperature Performance  
Excellent Chemical Resistance

#### Typical Properties

Color	White to Light Gray
Viscosity, cP	36,000 to 42,000
Specific Gravity @ 77°F	1.37

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
60 Mins @ 250°F	77	3000
	180	2900
	250	2500
	300	2100

#### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).**

#### Application

**Applying:** Allow material to come to room temperature before use. Bonding surfaces should be clean, dry and properly prepared. Apply adhesive to one or both substrates to be bonded. The parts must be held in contact until the adhesive is cured. It is important to remove uncured adhesive before curing. See "Clean Up" below for removal of uncured adhesive. Once cured, Loctite® EA 9459 is very difficult to remove. Large quantities of uncured adhesive may exotherm during the cure cycle. Avoid quantities larger than 10 grams in mass. Larger quantities in a bondline are safe to cure.

**Cure:** Loctite® EA 9459 can be cured for 60 minutes at 250°F. Faster cures can be achieved by using higher temperatures, for example, 30 minutes at 300°F. Cure temperatures above 350°F and below 250°F are not recommended. Cure time on your part will depend upon factors such as part geometry, materials to be bonded, bondline thickness and efficiency of the oven. Cure schedule should be confirmed with actual production parts and equipment. A clamping pressure of 15 psi is recommended to ensure that good contact is maintained during the cure cycle.

**Clean Up:** Uncured adhesive can be removed from the work area and application equipment by using many common

solvents and citrus cleaners. Consult with your supplier's information pertaining to the safe and proper use of solvents.

#### Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 2° to 8°C (36° to 46°F) unless otherwise labeled. Optimal storage conditions of this product is achieved with refrigeration: Refrigerated packages shall be allowed to return to room temperature prior to use. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

#### Note

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